



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.4311

Job Sheet 202904



15

Part No: 647.4311

Job Qty: 12-pcs

Part Name: RH Lower Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 12/18/19 Feb-8

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.06 CHG MATERIAL TO S.S.
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	12 pcs		12/18/19	0.17	0.73	Waterjet - Flow		TF March, 10, 2020
120	QC 2	12 pcs		12/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		TF March, 10, 2020
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S262271



Part: 647.4311

Job No: 202904

Serial No/Batch: S262271

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/17/20

Plex 11/5/19 10:42 AM Dart.lajeunesse.marie

130 QC 8	12 pcs	12/18/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - 2 - B4B	12 pcs	12/18/19	0.00 6.78	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	ML
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
150 QC 5	12 pcs	12/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	

DAS
MAR 11 2020 40
9-89

				QC 5 - 81	
160 Large Fab - Welded Assy-2-B4B	12 pcs	12/18/19	0.00 7.19	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	MV
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
170 QC 9	12 pcs	12/18/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	GL
				QC 9 - 9	
180 QC 5	12 pcs	12/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	GL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Spray Paint - 2 - B4B	12 pcs	12/18/19	0.00 1.19	Spray Paint - 1 - B4B	DAS
				Spray Paint - 2 - B4B	87 MAR 20 2020
				Spray Paint - 3 - B4B	9-89
				Spray Paint - 4 - B4B	
200 QC 14	12 pcs	12/18/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	DAS
				QC 14 - 19	82
				QC 14 - 43	9-89
				QC 14 - 24	MAR 23 2020
				QC 14 - 61	
				QC 14 - 81	
205 Outsource	12	12/18/19		ATE003-VC	5

210 Packaging 3-1 - Stock - B4B 15 pcs	12/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	DAS
			Packaging 3 - 3 - B4B ✓	CC5073 80
			Packaging 3 - 4 - B4B	9-89
			Packaging 3 - 5 - B4B	MAR 23 2020
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
220 QC 21 - SA 15 pcs	12/18/19	0.00 0.00	QC 21 - SA - 21 ✓	CC5073
			QC 21 - SA - 70	
			QC 21 - SA - 53	MAR 23 2020

Part Op 110 - 1-Cut 647.4310 plate 5.00X1.75 as per Dwg
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab) 1- Fabricate tube as per dwg by cutting (21.00") one end 30.1 degree and other end punch, bend and drill hole as per dwg
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Weld per dwg A/R S.S. rod Batch: M126585) Weld tube to plate as per dwg.
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Spray Paint / NDT Room) Prime as per dwg (see note 4) 5256137
 200 - (QC14- Inspect Spray Paint)
 210 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.7284 sf (.0607 ea)	110-Waterjet - Flow - 1	5257458
M304TR0.500W.049	304 Round Tube .500 X .049W	21 ft (1.75 ea)	140-Small Fab - 2 - B4B	5257890

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	1	275	0
140-Small Fab - 2 - B4B	M304TR0.500W.049	21	109	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	RH Lower Strut	5.000inches $\pm$ 0.010	5.010 4.990	5.002	
2	RH Lower Strut	1.750inches $\pm$ 0.010	1.760 1.740	1.757	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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